

Work Order ID 68147

Thursday, April 07, 2011 8:18:31 AM

Page 1

Item ID: D4324-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Arm Support Assembly

Start Date: 4/7/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-04-07* Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4324

A

100

Weld per dwg A/R S.S. rod Batch: *M 114509* 0.00



Large Fab

Memo

0.00

Large Fab

EL 11-4-8

(X2)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

CP 11-04-08

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Silva/08

(X2)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68147

Thursday, April 07, 2011 8:18:31 AM

Page 2

Item ID: D4324-043

Accept

Revision ID:

Item Name: Arm Support Assembly

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *ST-*

0.00



Packaging

Memo

0.00

Packaging

*MF**11-04-08*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/4/8**MF*
11-04-08

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 07, 2011 8:18:28 AM

Page 1

Work Order ID: 68147

Parent Item: D4324-043

Parent Item Name: Arm Support Assembly

Start Date: 4/7/2011


Required Date: 4/8/2011

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC


| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

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|--|--|-----------|----|--|--|-----|------|---------|---|---|--|-----------|--|
| AN310C3  Castellated Nut | | Purchased | No | | | 100 | Each | 52.0000 | 1 | 2 | | EL 11-4-8 | |
|--|--|-----------|----|--|--|-----|------|---------|---|---|--|-----------|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST349 | 52 | |
| 114304 | 2 | |
| 114714 | 50 | |

| | | | | | | | | | | | | | |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|-----------|--|
| D4324-3  Support Plate | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 2 | | EL 11-4-8 | |
|--|--|--------------|----|--|--|-----|------|--------|---|---|--|-----------|--|

B68149 x 2

| | | | | | | | | | | | | | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|-----------|--|
| D4324-7  Tube | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 2 | | EL 11-4-8 | |
|---|--|--------------|----|--|--|-----|------|--------|---|---|--|-----------|--|

B68151 x 2

| W/O: | | WORK ORDER CHANGES | | | | | | |
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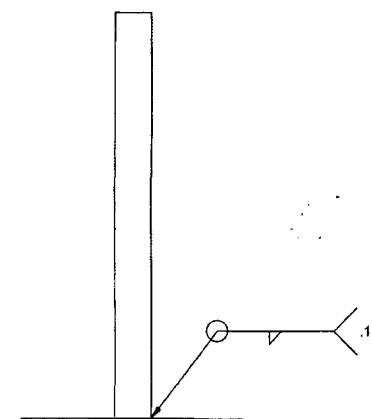
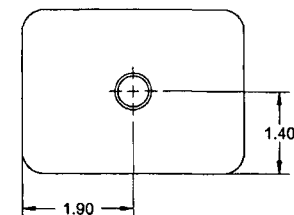
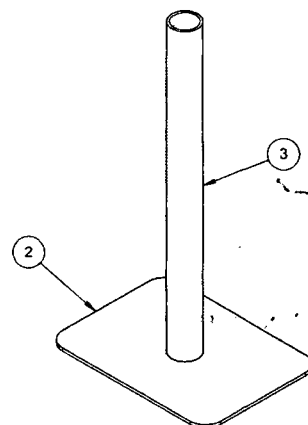
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NOTE: Date & initial all entries

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|-----|-------------|-------------------|
| 1 | X | D4324-041 | ARM REST ASSEMBLY |
| 2 | 1 | D4324-1 | BASE PLATE |
| 3 | 1 | D4324-5 | TUBE |



D4324-041 ARM REST ASSEMBLY
(REF. EAGLE DRAWING NO. D2046902 P/N EA20469-16)

#68147

RELEASED
2011-04-86

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.36 lbs
- 8) WELD PER DART QSI 004

| A | NEW ISSUE | RF | 11.01.31 |
|------------|---------------|---|--------------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. A |
| MFG. APPR. | RF | D4324 | SHEET 1 OF 5 |
| APPROVED | RF | TITLE | SCALE |
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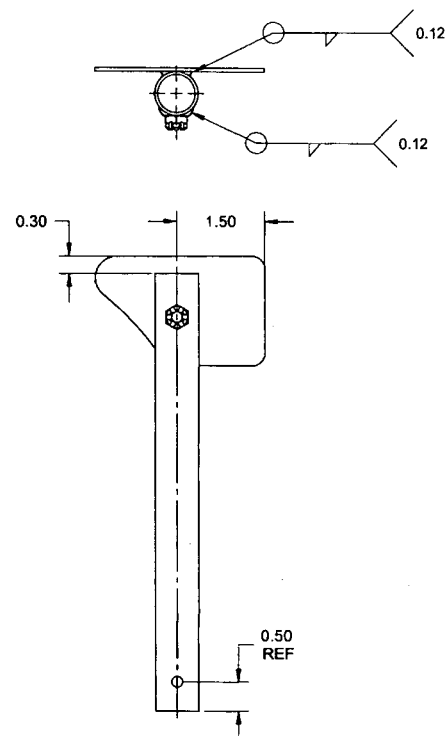
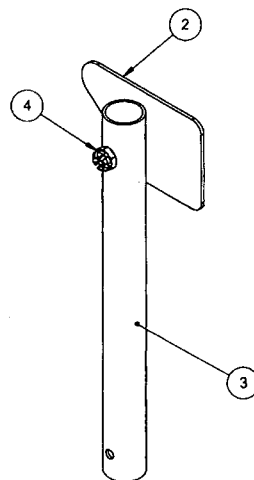
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| ITEM | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|----------------|----------------------|
| 1 | X | D4324-043 | ARM SUPPORT ASSEMBLY |
| 2 | 1 | D4324-3 | SUPPORT PLATE |
| 3 | 1 | D4324-7 | TUBE |
| 4 | 1 | AN310C3 | NUT, CASTELLATED |



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

#68147

RELEASED
2011-04-08
MAD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

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|------------|----------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. D4324 | REV. A |
| MFG. APPR. | | | SHEET 2 OF 5 |
| APPROVED | | TITLE VRD PARTS | SCALE NTS |
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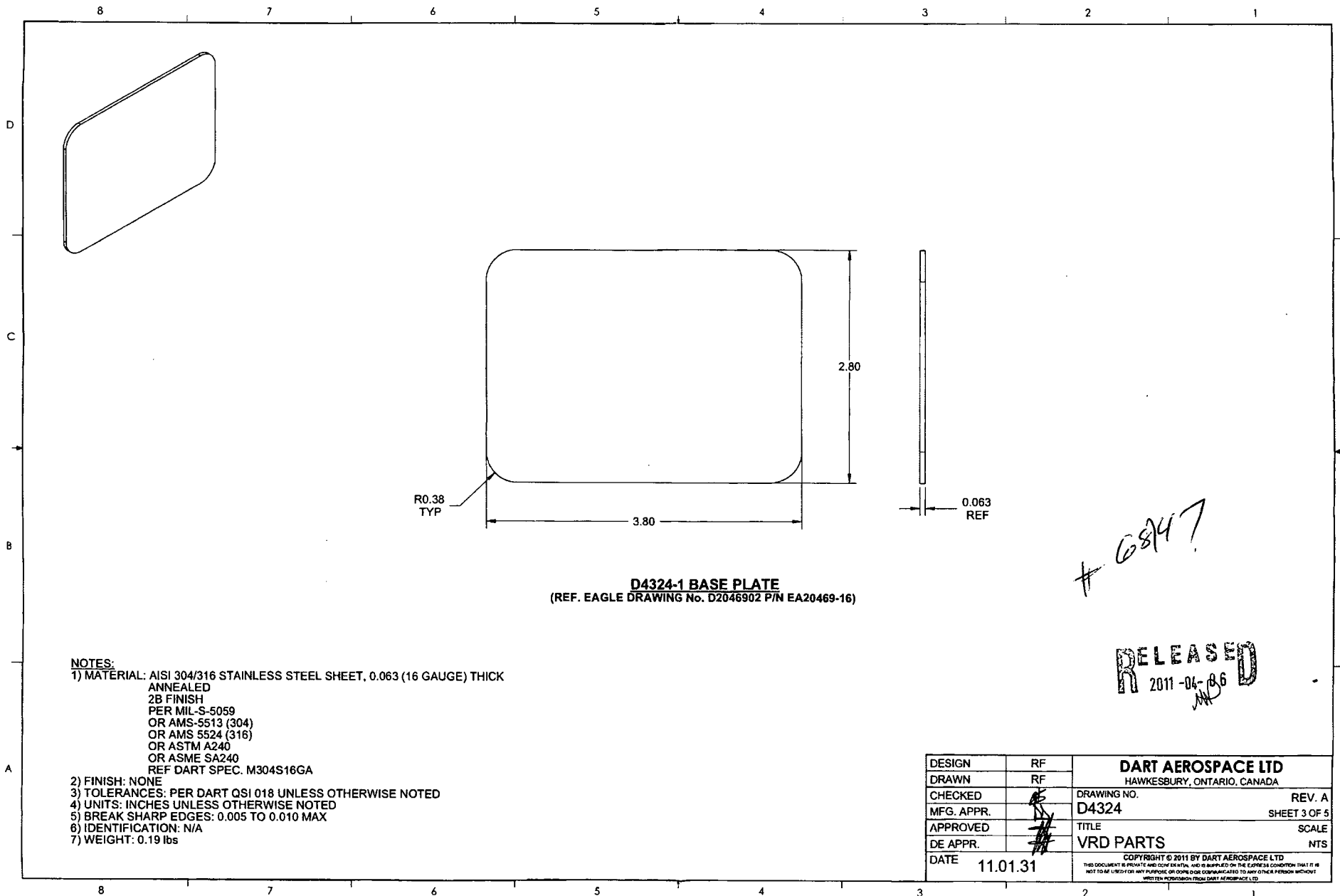
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries







D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

RELEASED
R 2011-04-06

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|---|---|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. |  | D4324 | SHEET 3 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | VRD PARTS | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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D

C

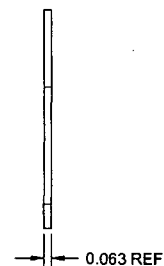
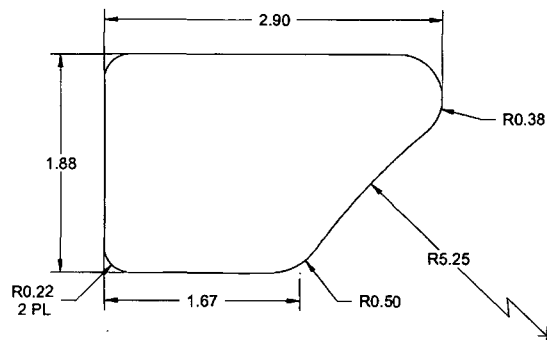
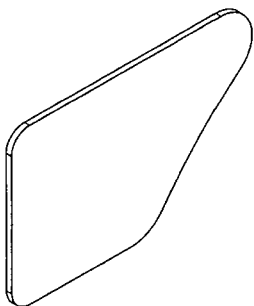
C

B

B

A

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS-5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

#68147

RELEASED
2011-01-06
JWD

| DESIGN | | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|------------|----------|----|--|--------------|
| DRAWN | | RF | | |
| CHECKED | | | DRAWING NO. D4324 | REV. A |
| MFG. APPR. | | | TITLE VRD PARTS | SHEET 4 OF 5 |
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| DATE | 11.01.31 | | | |

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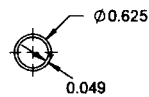
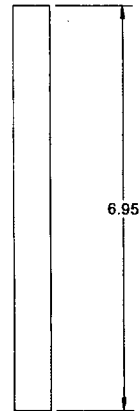
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

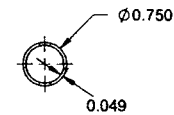
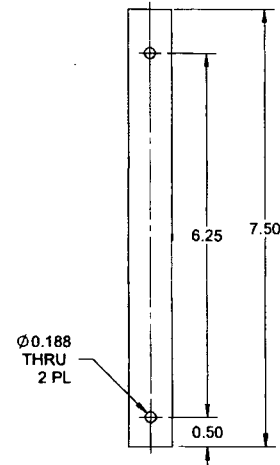
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NOTE: Date & initial all entries

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D4324-5 TUBE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)



D4324-7 TUBE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16)

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

| | | | |
|------------|--------------------|--|--------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4324 | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 5 OF 5 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | VRD PARTS | NTS |
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